

Work Order ID 155558

Tuesday, January 17, 2017 11:26:39 AM

155558

Page 1

Item ID: D3205-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pedal Bracket

Start Date: 1/4/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/17/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

Date: JAN 18 2017

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3205

Rev C

100

100

BAND SAW

0.00

Bandsaw

Memo

0.08

Jeaspa Bandsaw

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

DAS

44

9-89

17-02-07

110

110

HAAS CNC VERTICAL MACHINING #1

0.30

HAAS 1

Memo

0.69

HAAS CNC vertical machine #1

Machine D3205-1 as per Folio FA346 and Dwg D3205Identify as D3205-1

Deburr and Tumble

DAS

49

9-89

17/02/07

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.01

Quality Control

DAS

49

9-89

17/02/08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121		0.00							
121									
Mill Conv	Memo	0.20				6	0		DAS 32 9-89 17-02-08
Conventional Milling Machine	COUNTER SINK AS PER DWG								
122	QC2- Inspect parts off machine FAI/FAIB	0.00							
122									
QC	Memo	0.01				6	0		DAS 32 9-89 17-02-08
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.02				5	1		DAS 44 9-89 17-02-11
Quality Control									

P.T.O.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>155558</u> Part No. <u>D3205-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																					
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Countersink $\phi.415" \times 100"$ is too deep. (was drill @ $\phi.515" \times 100"$) RC operator				Scrap destroy no replace				J.C.L. 17-02-08																																																																					
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Work Order ID 155558

Tuesday, January 17, 2017 11:26:39 AM

155558

Page 3

Item ID: D3205-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pedal Bracket
Start Date: 1/4/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 1/17/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140	HandFinish	0.04							
Hand Finishing	Memo								
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	Powdercoat	0.02							
Powder Coating	Memo								
	Note: Cover the thread hole for D3205-1 before powder coat.START TIME: <u>10:40</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>11:10</u>								
160	QC3- Inspect Part Finish	0.00							
160	QC	0.01							
Quality Control	Memo								

Handwritten notes and stamps:
- Sequence 140: (X5) 20170213 DEB
- Sequence 150: 5 17-03-23
- Sequence 160: 5 MAR 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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NR2Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.01

Packaging

LOCATION : GA

6

DAS
6
9-89

MAR 24 2017

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

17/3/27 JH

MAR 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, January 17, 2017 11:26:38 AM

Page 1

Work Order ID: 155558

155558

Parent Item: D3205-1

D3205-1

Parent Item Name: Pedal Bracket

Start Date: 1/4/2017

Required Date: 1/17/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.06.09New issueKJ/RF
IPP Rev:B 08-12-16 attach DEO DD verified by:EC
REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T73B2.500X03.2
5

Purchased

No

100

f

6.2000

0.3646

2.302737

DAS

44

9-89

17-02-03

M7075T73B2 500X03 25

7075-T73 Bar 2.50 x 3.25

Location

Loc Qty

Loc Code

MAT

2.2

m135690

2.2

2.2.

MAT008

4

X m135792

4

.36

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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3AQ 14 28-0								Lead hand / Supervisor Approval Verification																	
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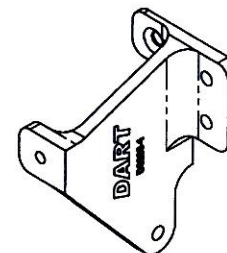
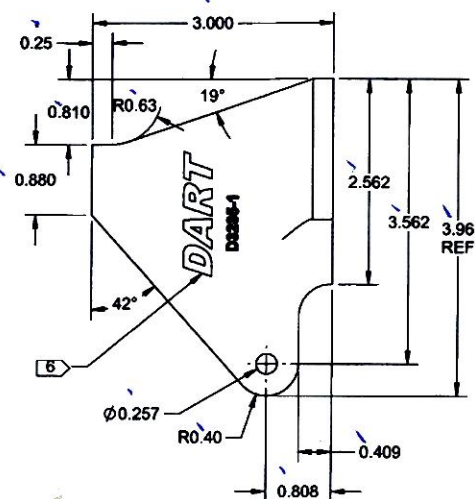
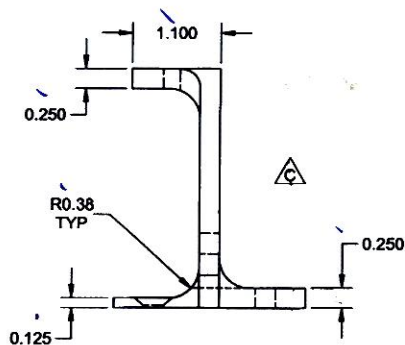
DART AEROSPACE LTD		Work Order: 155558
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.102	-		vern	mm L-05
0.250	+/-0.010	0.254	✓		micro	mm L-01
R0.38	+/-0.030	0.380	✓		RC	
0.125	+/-0.010	0.130	✓		micro	mm L-01
0.250	+/-0.010	0.252	✓		micro	m
2.380	+/-0.010	2.382	✓		vern	mm L-05
1.380	+/-0.010	1.381	✓		"	
0.500	+/-0.010	0.490	✓		"	
0.880	+/-0.010	0.882	✓		vern	mm L-05
Ø0.470 x 100°	+0.006/-0.001	0.476	✓		caliper	3CL-08
0.440	+/-0.010	0.436	✓		vern	mm L-05
0.600	+/-0.010	0.600	✓		"	
1/4-28UNF-313	N/A	1/4-28 UNF	✓		"	
0.250	+/-0.010	0.251	✓		micr	mm L-01
Ø0.257	+0.006/-0.001	0.258	✓		vern	mm L-05
1.750	+/-0.010	1.741	✓		"	
0.870	+/-0.010	0.870	✓		"	
0.440	+/-0.010	0.431	✓		"	
R0.25	+/-0.030	0.25	✓		RC	
3.000	+/-0.010	3.000	✓		vern	mm L-05
3.96	+/-0.030	3.957	✓		"	
0.409	+/-0.010	0.411	✓		Heighty	31006
0.808	+/-0.010	0.808	✓		"	
2.562	+/-0.010	2.563	✓		vern	mm L-05

Measured by: 49 9-89 JCL	Audited by: 44 9-89	Preliminary Approval:
Date: 17/02/08	Date: 17-02-11	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ	



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155558 Mc

RELEASE
2013-02-07
mo

NOTES:

- 1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
- 7) WEIGHT: 0.28 lbs

C	REMOVED GRAIN DIRECTION ON -1 (ZN B5-1) SEE PREVIOUS REV. FOR DETAILS. REF. PAR12-212	SFM	12.12.24
B	CONVERT DRAWING TO STANDARD FORMAT; 3.95 WAS 3.99 (ZN C2-1)*18" WAS 18" (D3-1, 42" WAS 41" (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. PL (ZN D1-1, D6-1, C4-2, D5-2, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 0
MFG. APPR.		D3205	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.12.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO YOU FOR YOUR COMPANY'S USE ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	